	er ID 59237 2010 9:49:51 AM											Page 1
Revision ID:	D3535-35 Wearshoe		A	Accept					Setup	Start Stop		
	5/27/2010 Start Qty		1881   118   118   1881   1881     1881   1881   1881   1881		Cust Item l Customer:	D:				стор		III
Approvals:	Process Plan:	Y	Date: <u>/0-5-28</u> Date:	Tooling: SPC (Y/N):		ate:		1		Start Stop		
Sequence ID/ Work Center ID Draw Nbr	Operation Description Revision Nbr	n		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
D3535	Rev B											
Waterjet FLOW CNC Waterjet	t1	ER JET  Iemo  -Cut as per I Deburr if neco	Dwg D3535 □Dwg Rev:	0.00 0.00 □Prog Rev:	<b>R</b>			181	U= 8°	-31	8	
110		parts off mad	chine FAI/FAIB	0.00				RIO	- <u>5</u> -5	<u>31</u>		
120 	QC8- Inspect p	parts - secon Iemo	d check	26)W 2 00.00	-131			(4B)	>			

Dail Acidabace Liu	Dart	Aeros	pace	Ltd
--------------------	------	-------	------	-----

W/O:			W	ORK ORE	DER CHAN	NGES					
DATE	STEP	PRO	OCEDURE CH	ANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·									
Part No	•	PAR #:	Fault Cat	egory:		NC	R: Yes	No <b>DQ</b>	<b>A</b> :	Date:	
	R	esolution:	Dispositi	on:		QA	N/C CI	osed:		Date: _	·
NCR:		\	WORK ORE	DER NON-	CONFOR	MANCE	(NCR	()			·
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Actio	Action S n Descriptio	Section B	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector
		•									
									-		

Work Order II Friday, May 28, 2010										Page 2
Item ID: D353 Revision ID: Item Name: Wears			Accept					Setup Sta		
Start Date: 5/27/ Required Date: 6/4/2 Reference:	<b>C</b> -3	100404 11070 1104 11   100404 11070 11071	 IDI	Cust Item I Customer:	D:				1188111881	<b>                                    </b>
	eess Plan:		Tooling: SPC (Y/N):		ite:		1	Run Sta Sto		
Sequence ID/ Work Center ID 130 Hand Hand Hand Hand Hand Hand Hand Hand	Operation Description  NC BRAKE  Memo		Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Brake NC  140  QC  Quality Control	1-Deburr if DT8261 and QC5- Inspect part compl Memo	necessary □2-Form on Brak DT8326. □3-Identify as D3 eteness to step on W/O	0.00 0.00	Jigs St (3)			(H3	)		

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  $\mathcal{N}/\mathcal{LS}$ 8  $\mathcal{E}$ 

0.00

0.00 7 9 10 (06/01

X13 8

Memo

W/O:			V	VORK ORDER CHA	ANGES		·			
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
***************************************										
Part No	:	PAR #:		tegory:	NCI	R: Yes	No <b>DQ</b>	\ <b>\</b> :	Date:	
		esolution:								
NCR:			WORK OR	DER NON-CONFO	RMANCE	(NCR	)			
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
	O.E.	Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	Section		Chief Eng	QC Inspector
	.									
					,					
						***				

#### Work Order ID 59237

Friday, May 28, 2010 9:49:51 AM



Page 3

Item ID:

D3535-35

Accept



Setup Start



**Revision ID:** 

Item Name: Wearshoe

Required Date: 6/4/2010

5/27/2010

**Start Oty: 12.00** Req'd Qty: 12.00



**Cust Item ID: Customer:** 

Reference:

**Start Date:** 

Approvals:

Process Plan:

Date: \_\_\_\_\_

Tooling:

Date:

Run

Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

170

Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

13 Bl 10-10-1

180

**Quality Control** 

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/0198) Nro-6-01

W/O:			W	ORK ORDER (	CHANGES	<u>_</u>				
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										·
Part No	•	PAR #:	Fault Cate	egory:	NO	CR: Yes	No DQ	<b>A</b> :	Date: _	
	R	esolution:	Disposition	on:	Q,	A: N/C CI	osed:		Date: _	
NCR:		\	WORK ORE	ER NON-CON	FORMANC	E (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Desc	cription	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
			i .							
		7								
						,				

#### **Picklist Print**

Friday, May 28, 2010 9:49:55 AM

Work Order ID: 59237

Parent Item:

D3535-35

Parent Item Name:

Component Item ID/

Wearshoe

Comments:

New Issue 07-02-15 JLM IPP Rev:A

IPP Rev:B

Item ID

As per Rev B 07-08-31 JLM

Purchased

Purch

Replacement Mfg/

Verified By:EC

Bin

Item No

**Primary** Location

Last

Location

100

Route Unit of Seq ID sf

Measure

Qty on Hand 172.9926

Loc Code

0.8022

Start Date: 5/27/2010

**Start Qty: 12.00** 

Qty per Kit

Otv 10.13305

Total

Issued (D. <

Qty

Date Issued

Status

Page 1

B 10-5-31

Required Date: 6/4/2010

Required Qty: 12.00

304/316	040	Sheet
JUT/JIU	.040	SHOO

Item Name

M304S20GA

Loc Oty
168.7278
168.7278
4.2648
2.7475
1.5173





W/O:			W	ORK ORDER CHANG	GES	·		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA: _	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:	Date: _	
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (NCF	R)		
DATE	STEP	Description of NC			tion B	Verification	n Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C		QC Inspector
				'				
				1 1				
			:					
	1		1					ļ.

DART AEROSPACE LTD	Work Order:	59237
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	000.6	1			
1.885	+/-0.010	1,886	৮			
6.00	+/-0.030	6.00	u			
6.75	+/-0.030	6.75	٧			
Ø0.188	+0.005/-0.001	1190	7			
23.250	+/-0.010	53.750	<u></u>			
19.750	+/-0.010	19.750	· .			
17.750	+/-0.010	17,750	8			
14.250	+/-0.010	14.750	×			
9.500	+/-0.010	9.50	7			
4.750	+/-0.010	4,750	×.	180.8		
0.300	+/-0.010	,307	84			
0.300	+/-0.010	.308	>			
0.038	+/-0.010	1040	4			

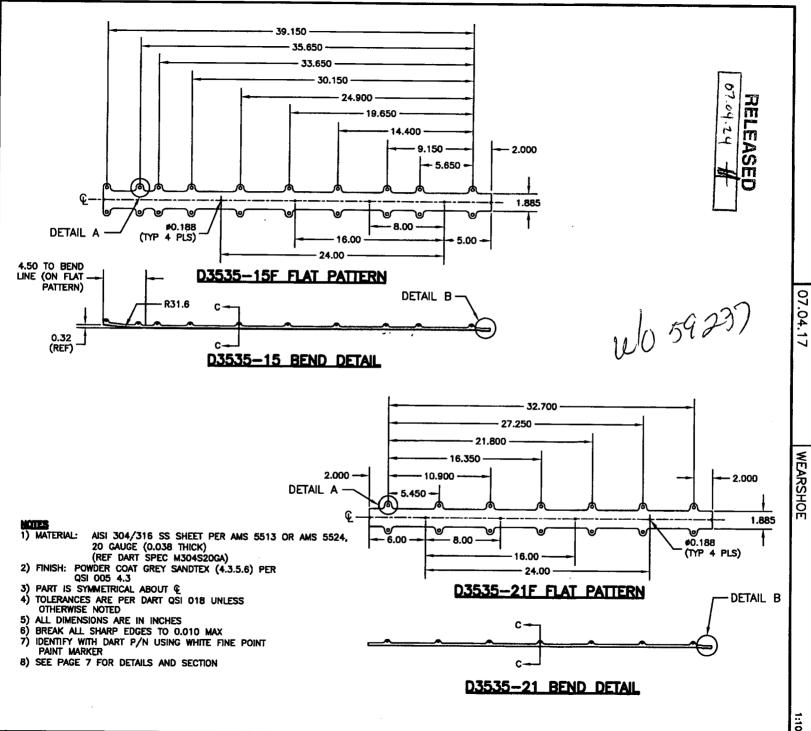
Measured by:	<u>i</u> B	Audited by:	Prototype Approval:	N/A
Date:	10-5-31	Date: (0(073)	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM	B

W/O:	1-		W	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE By					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									r roa wigi	
7"1									:	
<b></b>										
Part No		PAR #:								
· · · · · · · · · · · · · · · · · · ·	Re	esolution:							Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	ICR)				
DATE	STEP	Description of NC		· <u></u>	Section B		Verification		Approval	Approval
	3	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section	on C	Chief Eng	QC Inspector
				<u>'</u>		1				
·										

W/O:			V	VORK O	RDER CHAN	IGES					i, #-
DATE	STEP	PRO	CEDURE CH	HANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										Prod Wgr	
				·							
Part No	:	PAR #:	Fault Ca	tegory:	· · · · · · · · · · · · · · · · · · ·	NC	R: Yes	No <b>DQ</b>	A:	Date:	
						QA: N/C Closed: Date:					
NCR:		\	WORK OR	DER NO	N-CONFORM	MANCE	(NCR	)			
DATE	STEP	Description of NC				ection B		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Act	tion Description Chief Eng	n 	Sign & Date	Section C		Chief Eng	QC Inspector
•										,	
					<del></del>						
						- 1.A					· · · · · · · · · · · · · · · · · · ·
										:	
NOTE: D	ate & initi:	al all entries									

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



캪

DOCUMENT

Ø

Copyright © 2006 by DART AEROSPACE USA, IN PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART

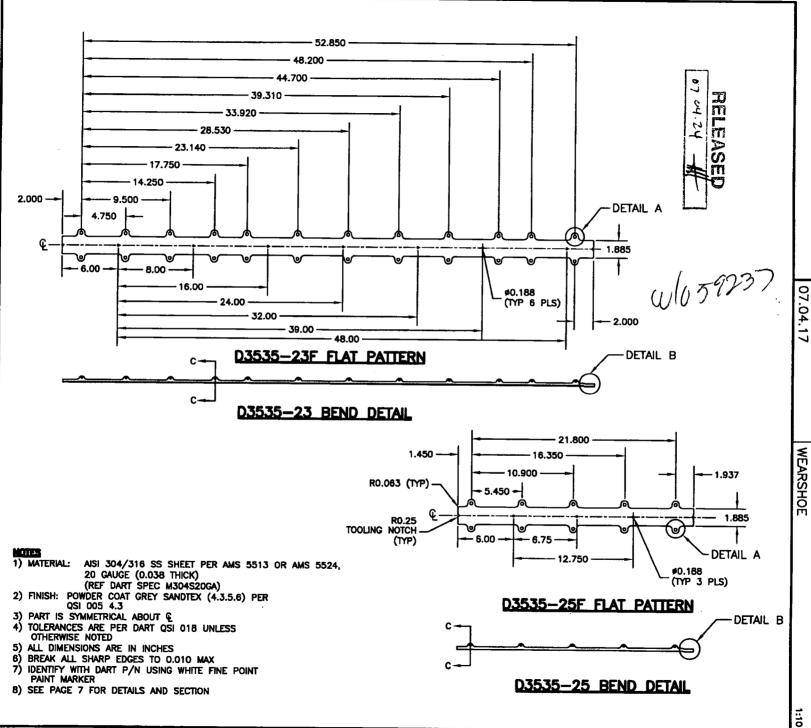
INC.
NOT TO BE USED FOR ANY I

PURPOSE

유

COPIED

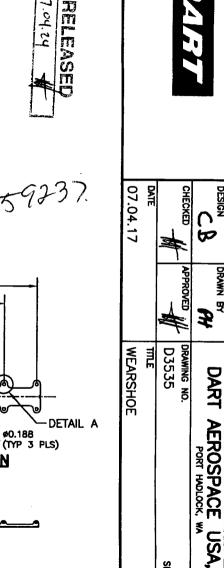
W/O:			W	ORK ORDER CHANG	iES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву			Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:						:		
-									
Part No:		PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
				oosition:					
NCR:		V	VORK ORE	DER NON-CONFORMA	ANCE (NC	R)			
DATE STE		Description of NC	1		ion B	Verific	Verification	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
							<del> </del>		
11000	<del></del>	<u> </u>	1		1				



돺 DOCUMENT ᢐ Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. PURPOSE 욹 COPIED

W/O:			WC	RK ORDER CHAN	GES					<b>.</b>
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									Prod Wigi	
		÷								
	1									
Part No		PAR #:								
	Re	esolution:							Date: _	
NCR:		1	WORK ORDE	R NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC					Verific	ation	Approval	Approval
	012.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
						100				
·								.,,,		



SHEET

SCALE 읶

1:10

REV.

NC.

42.40.La

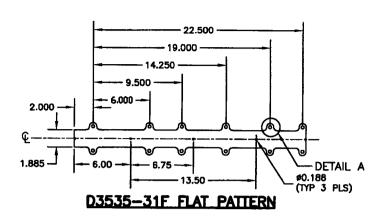
24.500 21.000

D3535-33 BEND DETAIL

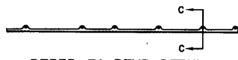
15.250

9.500

6.000 -







1) MATERIAL:

봀

DOCUMENT

ᅈ

Copyright © 2006 by DART AEROSPACE USA, INC.

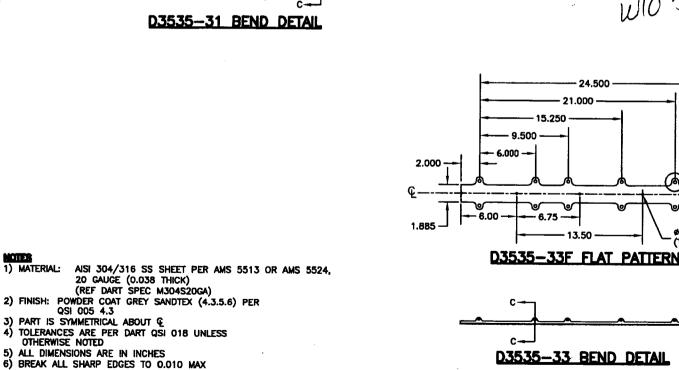
PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

유

COPIED

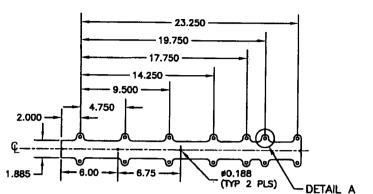
- AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER

- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

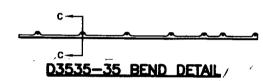


W/O:			W	ORK ORDER CHANG	BES		******			
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #:								
	Re	solution:	Dispositio	n:	QA:	WC CI	osed:	<del></del>	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR	)			
DATE	STEP	Description of NC	Corrective Action Section			<u> </u>	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
						-				
				,		****				
						•••				-

1:10

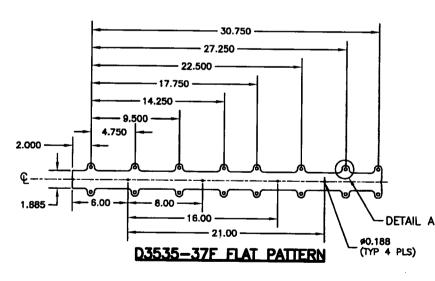


#### D3535-35F FLAT PATTERN



42.40.60

RILLIAS



D3535-37 BEND DETAIL

# 1) MATERIAL:

- AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524. 20 GAUGE (0.038 THICK)
- (REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

FROM

PURPOSE

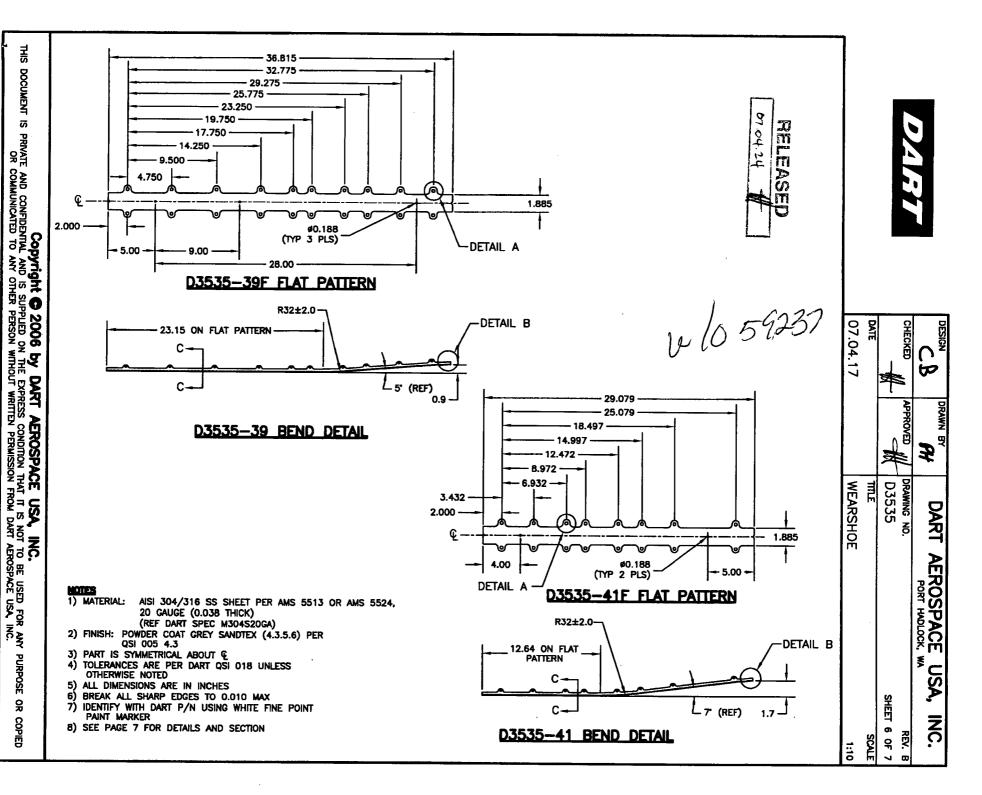
ဝ္က

COPIED

봀

Dart Aerospace Ltd
--------------------

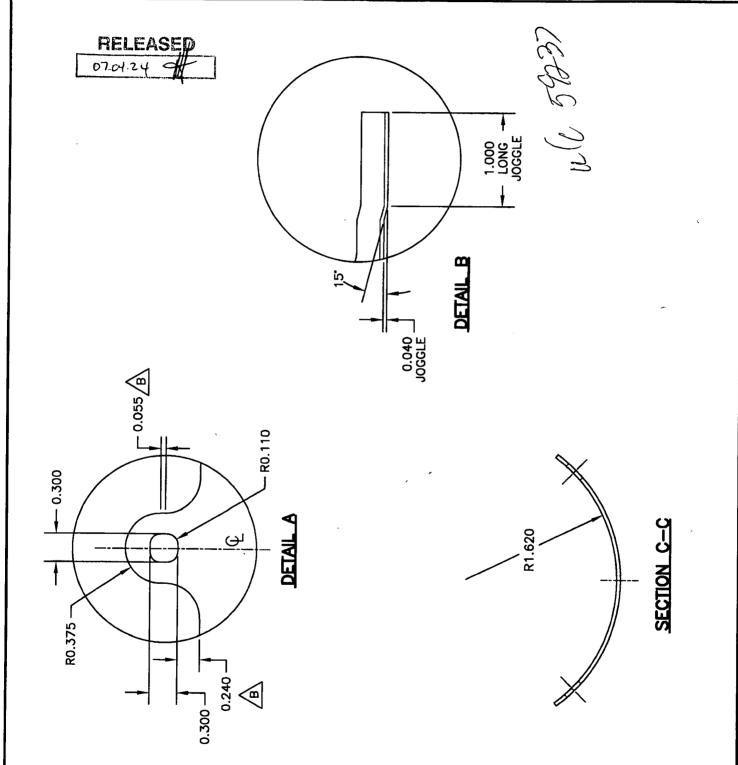
W/O:			WC	RK ORDER CHANG	EC			-
DATE	STEP	PRO	PROCEDURE CHANGE By Date Qty					Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQA:</b> _	Date:	
		esolution:						
NCR:			WORK ORD	R NON-CONFORM	ANCE (NCR	)	***************************************	
DATE	STEP	Description of NC			ion B	Verification	on Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								,
								;
				•				



W/O:			V	/ORK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE   By   Date   Qty   Chief End				Approval Chief Eng / Prod Mgr	Approval QC Inspector	
•									
								44.5	
Part No	):	PAR #:	Fault Ca	tegory:	_ NCR: Yes	Date: _			
	Re	solution:	Disposit	ion:	_ QA: N/C Cld	osed:		Date:	
NCR:		,	WORK OR	DER NON-CONFORM	ANCE (NCR	)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng	ion B Sign & Date			Approval Chief Eng	Approval QC Inspector
			Office Eng	· ·	Date				
							,		



_ CB	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED XX	APPROVED _//	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



Copyright 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Dart Aerospace	Ltd
----------------	-----

W/O:		WORK ORDER CHAN	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
***							
Part No	):	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date:	

Resolution:		Disposition:		QA: N/C Clos	sed:	Date:		
NCR:		\	WORK OR	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Varification		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
				1				
					ļ			
								*
	-							
		,						

ÇZ:>